

NCP-19-7698



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-646-041
Job Sheet 197065



Part No: D119-646-041

Job Qty: 1 pcs

Part Name: AW119 Replacement Skidtube with Wearpads - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/27/19

Job Tracking No:

Due Date: 4/17/20

Created By: Jennifer Renwick

Type: SOLD

Description: Order 17375

Note: DWG IIN-D119-646 REV D, D3887-041 REV E SHEETS 1,2,5,7,8,10,11 IPP RevA: New issue DD verified by:EC IPP rev B 10.02.22 per PAR 09-043 EC verified by:DD IPP REV C 12.11.05 (DEOD3887-B-1)(ecn 12-675) DD ver:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD ver:JLM IPP REV:E 17.05.19 as per dwg D3887 rev.e DD ver:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Workcenter/Supplier		Sign-off
						Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	4/17/20	0.00	0.25	Skidtubes - 1		
						Skidtubes - 2		
						Skidtubes - 3		
						Skidtubes - 4		
						Skidtubes - 5		
						Skidtubes - 6		
						Skidtubes - 7		
120	Handfinish - 1-1 Chemical-B4B	1 pcs	4/17/20	0.00	0.83	Handfinish - 1 - 1 - B4B		
						Handfinish - 1 - 2 - B4B		
						Handfinish - 1 - 3 - B4B		
						Handfinish - 1 - 4 - B4B		
						Handfinish - 1 - 5 - B4B		
						Handfinish - 1 - 6 - B4B		
						Handfinish - 1 - 7 - B4B		
						Handfinish - 1 - 8 - B4B		
						Handfinish - 1 - 9 - B4B		
						Handfinish - 1 - 10 - B4B		
						Handfinish - 1 - 11 - B4B		
						Handfinish - 1 - 12 - B4B		
						Handfinish - 1 - 13 - B4B		
						Handfinish - 1 - 14 - B4B		
						Handfinish - 1 - 15 - B4B		
						Handfinish - 1 - 16 - B4B		
						Handfinish - 1 - 17 - B4B		
						Handfinish - 1 - 18 - B4B		
						Handfinish - 1 - 19 - B4B		
						Handfinish - 1 - 20 - B4B		
						Handfinish - 1 - 21 - B4B		
						Handfinish - 1 - 22 - B4B		



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S198621



Part: D119-646-041

Job No: 197065

Serial No/Batch: S198621

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/10/17, TC STC LoA P.

Plex 6/27/19 2:58 PM Dart.Renwick.Jennifa

121 QC 7	1 pcs	4/17/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 8	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
122 QC 5	1 pcs	4/17/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
130 Skidtubes - 2 - B4B	1 pcs	4/17/20	0.00 1.54	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
135 QC 5	1 pcs	4/17/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	

140 Skidtubes - 3 - B4B	1 pcs	4/17/20	0.00 1.47	QC 5 - 40	
				Skidtubes - 1 - B4B	00
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MLG/TW
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
150 QC 5	1 pcs	4/17/20	0.00 0.00	Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
QC 5 - 40					
160 Skidtubes - 4 - B4B	1 pcs	4/17/20	0.00 1.61	Skidtubes - 1 - B4B	00
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 5	1 pcs	4/17/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS
				QC 5 - 24	24
				QC 5 - 3	9-89
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
180 QC 10	1 pcs	4/17/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	DAS
				QC 10 - 24	24
				QC 10 - 43	9-89
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	4/17/20	0.00 0.83	Handfinish - 2 - 1 - B4B	BE 19-10-02
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Powdercoat - 1 White G(A)- B4B	1 pcs	4/17/20	0.00 0.22	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	DR 11-03
				Powdercoat - 4 - B4B	
210 QC 3	1 pcs	4/17/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	

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						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	BER 19-10-04
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
220 Handfinish - 4-1-Assembly-B4B	1 pcs	4/17/20	0.00	3.83		Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	BER 19-10-04
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
240 Handfinish - 4-2-Assembly-B4B	1 pcs	4/17/20	0.00	2.00		Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	BER 19-10-04
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
245 QC 5	1 pcs	4/17/20	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	

				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
260 Packaging 3-1 - Stock - B4B	1	4/17/20	0.00 0.00	Packaging 3 - 1 - B4B	OCT 09 2019
pcs				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
265 DC - 1 - B4B	1	4/17/20	0.00 0.00	DC - 1 - B4B	NOV 07 2019
pcs				DC - 2 - B4B	
270 QC 21 - FG	1	4/17/20	0.00 0.00	QC 21 - FG - 21	NOV 07 2019
pcs				QC 21 - FG - 70	
				QC 21 - FG - 53	

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8"); 3- Ensure squareness of ends and scribe batch#

120 - (Chemical Conversion Coat per QSI005 4.1)

121 - (QC7-Inspect Chemical Conversion Coat)

122 - QC5- Inspect part completeness to step on W/O

130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R

135 - (QC5- Inspect part completeness to step on W/O)

140 - 1- Bend FWD end of tube using bender 1 and FOLIO 31 bend prog. D3887.***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887.***Verify measurement*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size.(verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. 8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 9- C'sink FWD cap hole as per detail "C" 10- Drill holes for wearpads using DT8931, open to 0.297". 11- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 12- Deburr and blow out chips from inside of tube.

150 - (QC5- Inspect part completeness to step on W/O)

160 - NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R 2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3887. 4- Deburr & Scribe batch # on Aft end of tube.

170 - (QC5- Inspect part completeness to step on W/O) TEST FIT USING FIXTURE DT10091.

180 - (QC10- Inspect visual per QSI004- ground welds)

190 - Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME:

OVEN TEMPERATURE: _____ FINISH TIME: _____

210 - (QC3- Inspect Part Finish)

220 - (Assemble as per dwg) 1-Install inserts as per Dwg D3887.

240 - (Assemble as per dwg) 1-Install inserts as per Dwg D3887. 2-Install wearpads, gaskets as per Dwg D3887. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 5200625 Sikaflex expire date: 20/07 3-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 5138843 4 -Inspect for foreign objects as per QSI 024 5 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 5200625 Sikaflex expire date: 20/07 6 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 5200625 Sikaflex expire date: 20/07 7- Wing Walk as per dwg and QSI Batch: 5209362

245 - (QC5- Inspect part completeness to step on W/O)

260 - Identify as per dwg & Stock Location: _____

265 - Photocopy bluefile & type labels per PPP D119-646-041 CHG005

270 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n - 1" Beam Tube 4"	1 pcs (1 ea)	110-Skdtubes - 1	5168271
D3885-1	Standard Web	1 pcs (1 ea)	130-Skdtubes - 2 - B4B	5180313
D2579	Crossbolt Spacer	2 pcs (2 ea)	140-Skdtubes - 3 - B4B	5097840
D2855-5	Cap	1 pcs (1 ea)	160-Skdtubes - 4 - B4B	5010108
D3681-1	Spacer	12 pcs (12 ea)	160-Skdtubes - 4 - B4B	5211030
D3903-1	Spacer	12 pcs (12 ea)	160-Skdtubes - 4 - B4B	5211415
ALS4-1032-130	Rivnut	33 Ea (33 ea)	240-Handfinish - 4-2-Assembly-B4B	5057252
ALS4-1032-225	Rivnut	1 Ea (1 ea)	240-Handfinish - 4-2-Assembly-B4B	5192155
AN3C4A	Bolt	6 Ea (6 ea)	240-Handfinish - 4-2-Assembly-B4B	5218780
AN3C5A	Bolt	26 Ea (26 ea)	240-Handfinish - 4-2-Assembly-B4B	5216219
D2855-3	Cap	1 pcs (1 ea)	240-Handfinish - 4-2-Assembly-B4B	5126403
D3492-5	Plug	24 pcs (24 ea)	240-Handfinish - 4-2-Assembly-B4B	5197670
D3672-1	Washer, Phenolic	2 pcs (2 ea)	240-Handfinish - 4-2-Assembly-B4B	5164008
D3847-1	Wearpad	5 pcs (5 ea)	240-Handfinish - 4-2-Assembly-B4B	5211374
D3847-11	Wearpad	1 pcs (1 ea)	240-Handfinish - 4-2-Assembly-B4B	5136646
MS24694-C52	Screw	2 Ea (2 ea)	240-Handfinish - 4-2-Assembly-B4B	5067269
NAS1149C0332R	Washer (AN960C10L)	32 Ea (32 ea)	240-Handfinish - 4-2-Assembly-B4B	5193136
NAS1611-005	O-Ring	24 Ea (24 ea)	240-Handfinish - 4-2-Assembly-B4B	5194425

M.U. 612268

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skdtubes - 1	D2500-1-190	1	83	0
130-Skdtubes - 2 - B4B	D3885-1	1	20	0
140-Skdtubes - 3 - B4B	D2579	2	93	0
160-Skdtubes - 4 - B4B	D2855-5	1	41	0
	D3681-1	12	84	0
	D3903-1	12	79	0
240-Handfinish - 4-2-Assembly-B4B	ALS4-1032-130	33	7,265	0
	ALS4-1032-225	1	915	0
	AN3C4A	6	1,357	0
	AN3C5A	26	962	0
	D2855-3	1	78	0
	D3492-5	24	186	0
	D3672-1	2	1,633	0
	D3847-1	5	21	0
	D3847-11	1	8	0
	MS24694-C52	2	60	0
	NAS1149C0332R	32	4,682	0
	NAS1611-005	24	454	0

Part Specifications

Specifications could not be found.

Plex 6/27/19 2:58 PM Dart.Renwick.Jennifer

SPECIFICATION CONTROL DRAWING

D2500-1-XXX EXTRUSION & D2500-3-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: D2500-1 = 0.143 lb/in, D2500-3 = 0.066 lb/in

8) FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG). D2500-1 EXTRUSION MANUFACTURED FROM:

- A) BON L DIE # 897105 -> PREFERRED
- B) CARADON MIDEAST DIE # PAH-28030
- C) CARADON MTL DIE # MH-18868

9) FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG). D2500-3 EXTRUSION MANUFACTURED FROM:

- A) CARADON INDALEX DIE # MS-18867

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 197065

JUL 04 2019

RELEASED
2010-02-02

H	REDRAW & REFORMAT DWG; CORRECT BON L DIE # TYPO (ZN B8-1), ADD AMS & ASTM MAT'L OPTION (ZN D8-1), TOLERANCES NOW PER CARADON DWG (SHT 2)	CP	09.07.16
G	ADD DIE NUMBERS & 'DIMS IN INCHES' NOTES	PH	07.04.17
F	CHANGE MAT. TO 6061-T6	DS	97.09.29
E	CHANGE MATERIAL TEMPER	DS	96.10.24
D	ADD MATERIAL PROPERTIES	DS	96.10.07
C	ADD D2500-3 WEB	BW	96.04.26
B	CHANGE INTERNAL WEB	DS	96.03.24
A	NEW ISSUE	DS	96.03.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2500 REV. H
SHEET 1 OF 2
TITLE EXTRUSION SCALE NTS

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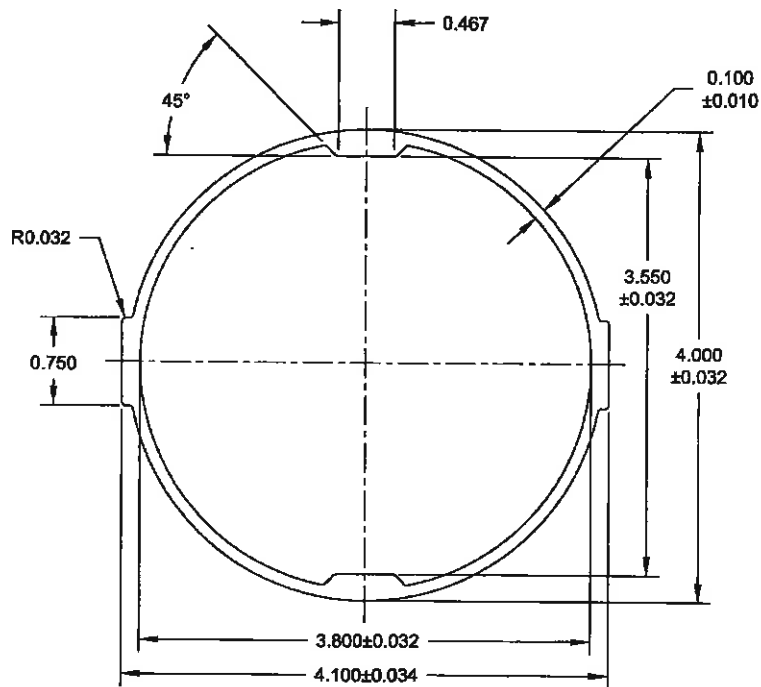
8 7 6 5 4 3 2 1

D

C

B

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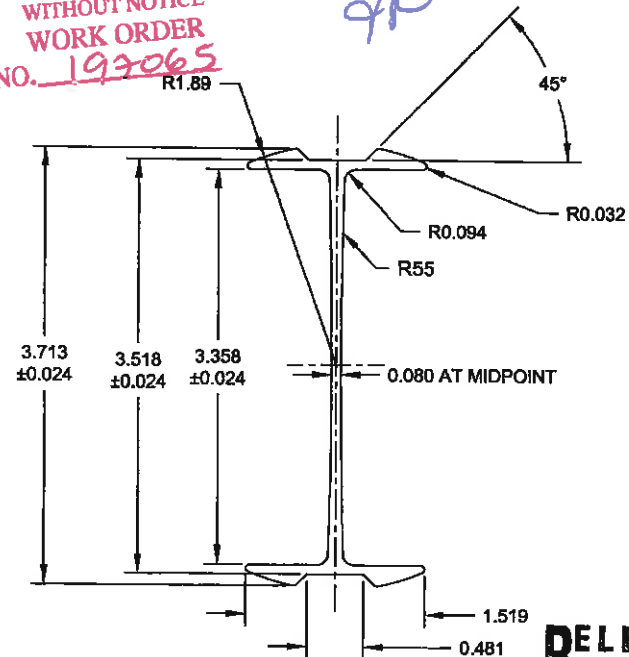


D2500-1

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WORK ORDER
NO. 197065

JUL 04 2019

91



D2500-3

RELEASED
2010-07-02
mp

DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>JP</i>	D2500	SHEET 2 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	EXTRUSION	NTS
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8 7 6 5 4 3 2 1

Entered: MR Date: Nov 8/19



NCR No. 19-7698 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>D119-646-0419</u> Part No. <u>197065</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☒ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date: <u>2019-08-08</u>		Sequence #: <u>140</u>		QTY Affected: <u>1</u>		MRB (QSI042)	
Description Work Order Deviation				Disposition		<u>NO</u> <u>19/08/08</u>	
Fwd Bends Height @ 4.875 0.015" out of tolerance Dwg tolerance 5.07 ± 0.18				small deviation, no impact on form, fit, function		Completed By	
						<u>NO</u> <u>19/08/08</u>	
						Lead hand / Supervisor <u>TR</u> <u>19-0808</u>	
QC / QA Coordinator		<u>DAS</u> <u>68</u> <u>9-89</u> <u>AUG 08 2019</u>					
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					